

Date: Thursday, 1/17/2008 3:23:58 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DUCT	
Job Number : 36813		
Estimate Number : 12316		
P.O. Number :	Part Number : D34733	OL PER REV B 08.01.10
This Issue : 1/17/2008 S.O. No. :	Drawing Number : D3473 REV B	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B	
Previous Run : 34419	Material :	
Written By :	Due Date : 2/10/2008	Qty: 10 Um: Each
Checked & Approved By : <u>JB 08 01 18</u>		
Comment : Est Rev:A New Issue 06-03-02 JLM		
Est Rev:B As per Rev B 06-05-24 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.3321 sf(s)/Unit Total : 3.3212 sf(s)

304/316 0.018 SHEET

Batch: 105591 IB 8-1-23

2.0	WATER JET <u>105591</u>	FLOW WATER JET
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Comment: FLOW WATER JET

Cut as per Dwg D3473

Dwg Rev: B IB 8-1-23

Prog Rev: B

(10)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-1-23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/01/25

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary. IB 8-1-23

2-Form as per Dwg D3473 using DT8860

JB 08/1/28 (10)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: AD Date: 08/01/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 1/17/2008 3:23:58 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUCT

Job Number: 36813

Part Number: D34733

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/1/09 (10)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: 163

8/1/30 50 (10x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/1/31

Job Completion



2008/1/30 (10)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

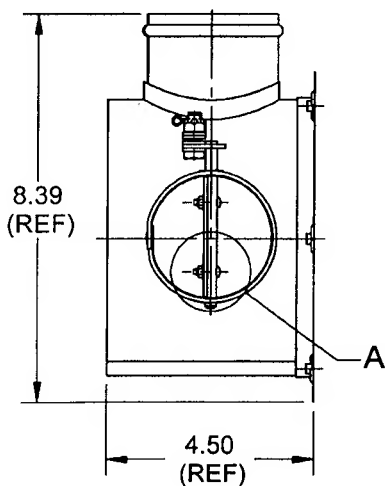
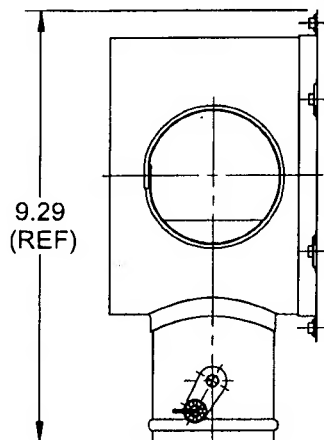
NOTE: Date & initial all entries





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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3473	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	

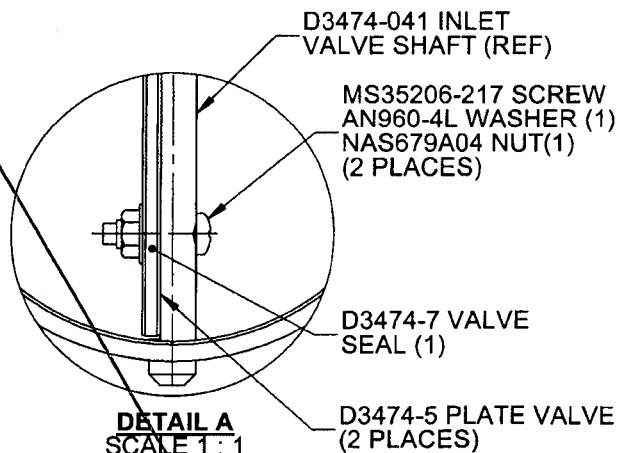
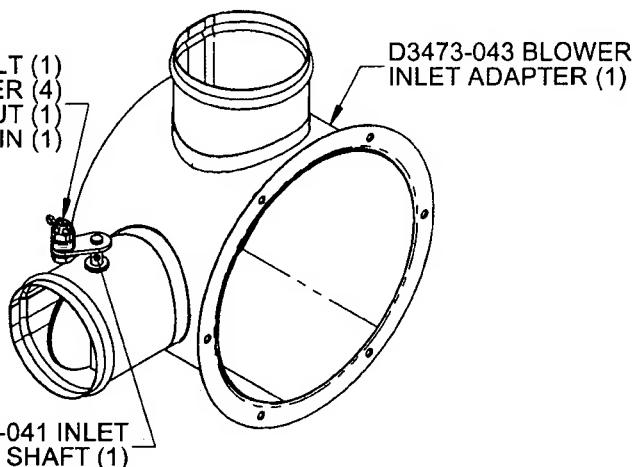
RELEASED  
06-05-16



UNDER REVIEW

02.09.03  
Dir + Manufacturing  
(Mktg)

D3470-9 BOLT (1)  
AN960-416 WASHER (4)  
AN310-4 NUT (1)  
MS24665-153 COTTER PIN (1)



### D3473-041 BLOWER INLET ADAPTER

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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NO. 36813

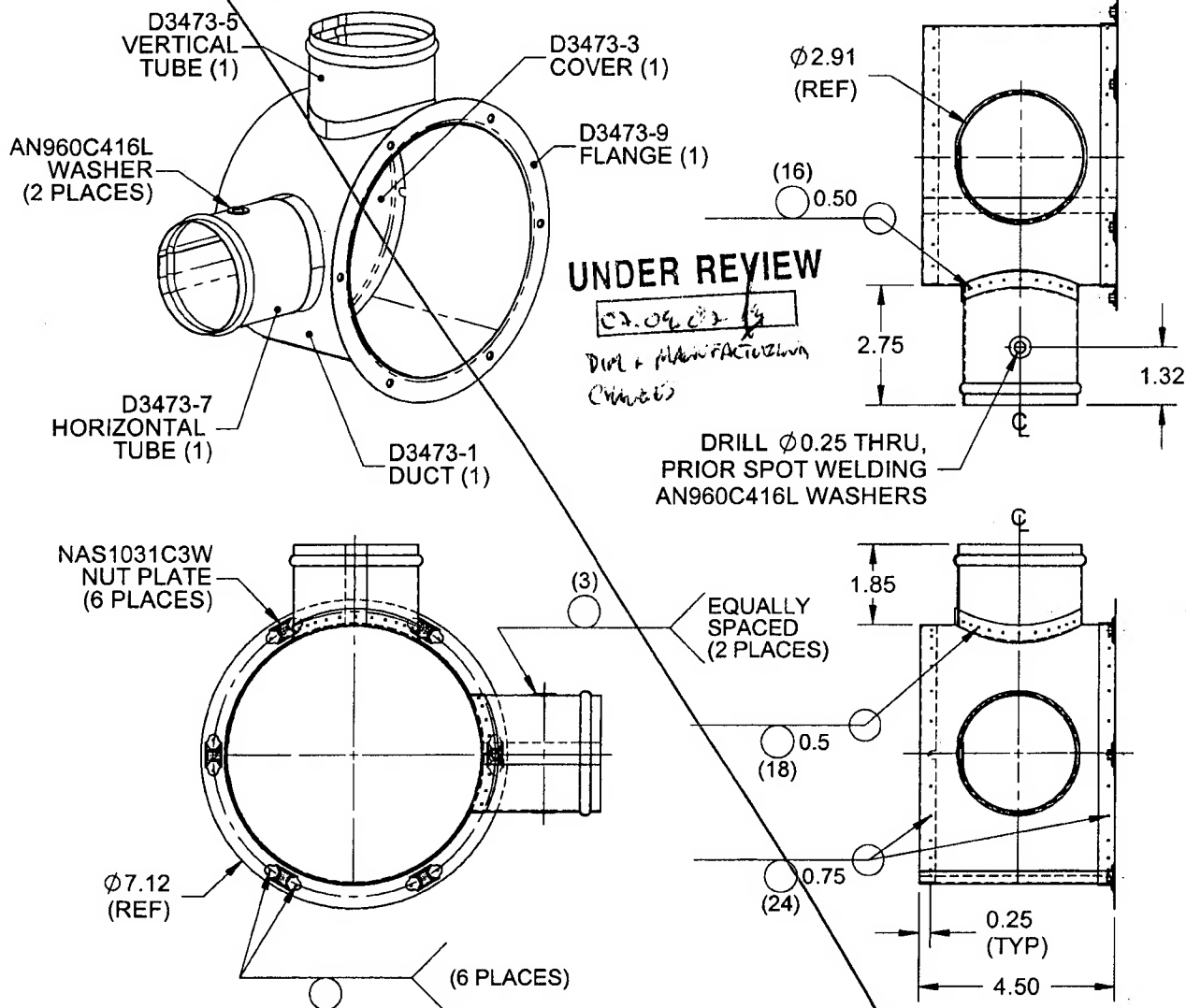
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED  
06.05.16



### D3473-043 BLOWER INLET WELDMENT

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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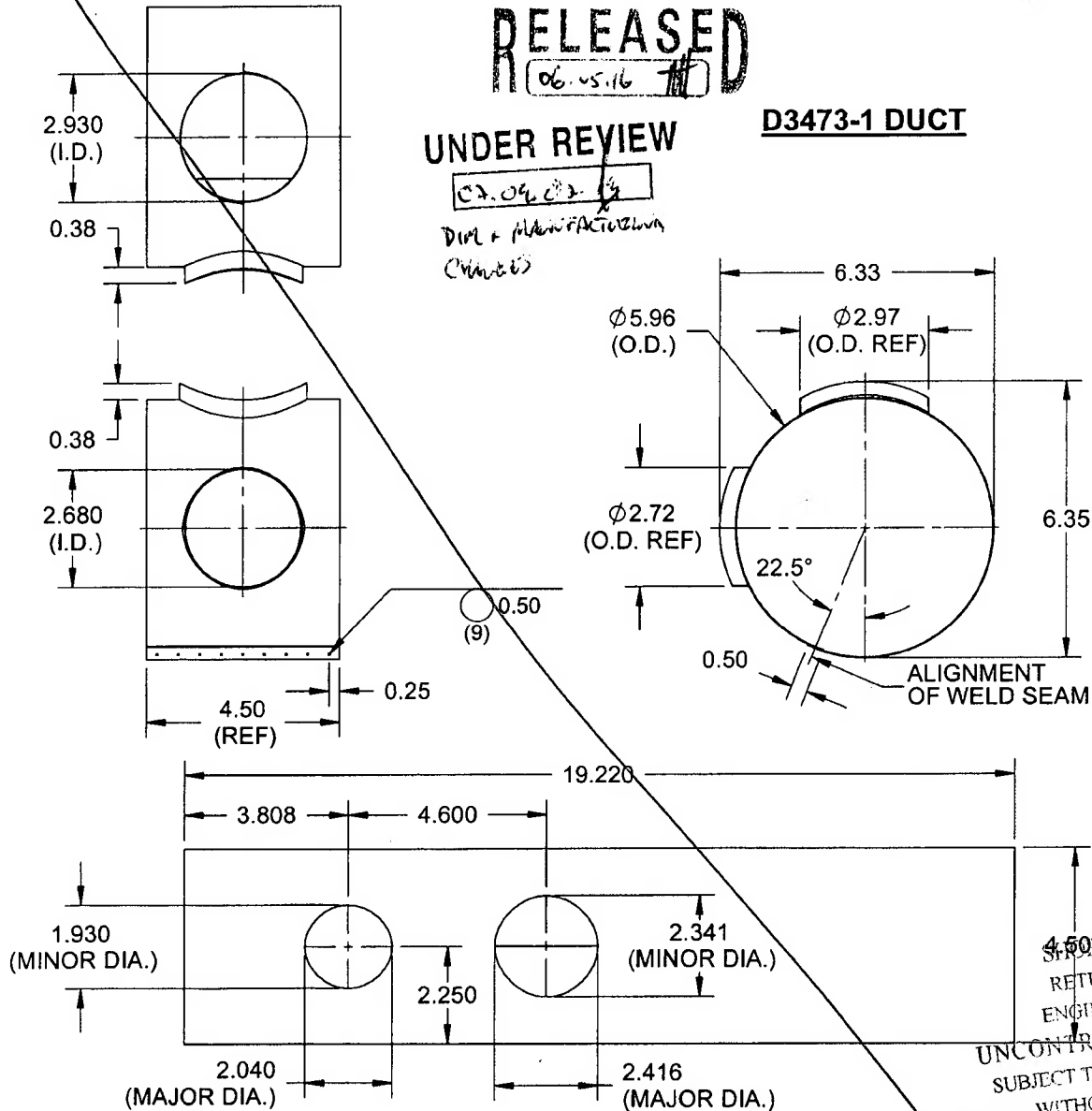


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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:4

RELEASED  
06.05.16

UNDER REVIEW

D3473-1 DUCT



### D3473-1F DUCT FLAT PATTERN

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

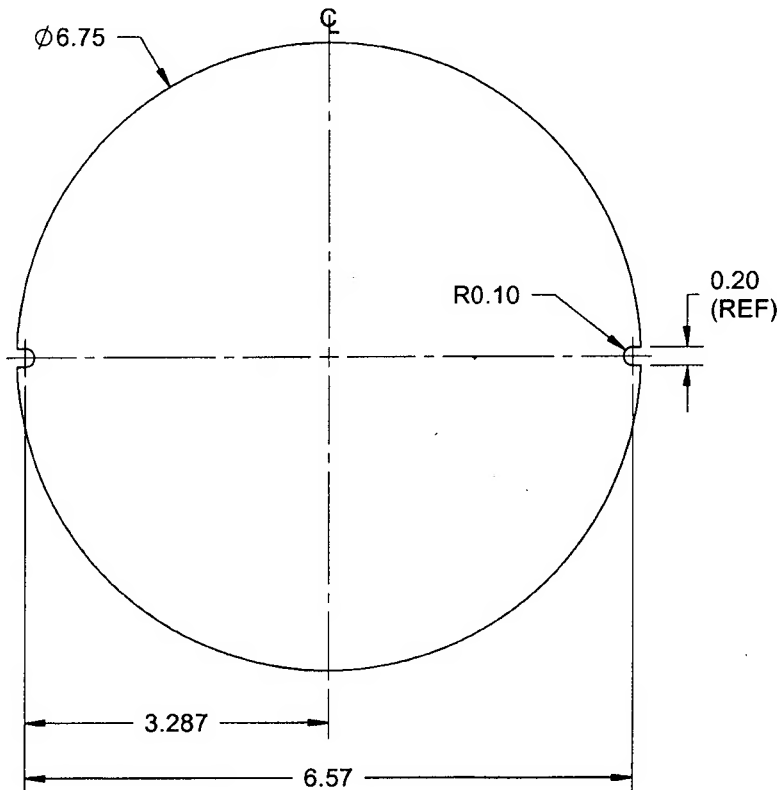
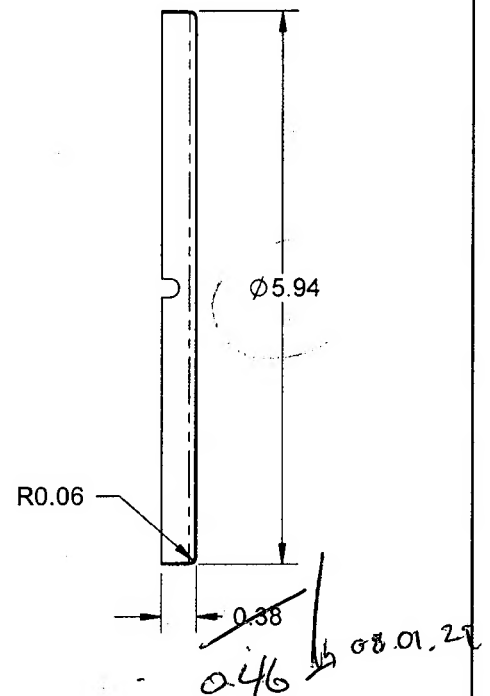
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DATE <b>06.05.16</b>	TITLE <b>BLOWER INLET ADAPTER</b>		SCALE 1:2

**RELEASED**  
06-05-16 *H***UNDER REVIEW**07.09.16 *B*DIP + MANUFACTURING  
CHECKS08.01.18 *H***D3473-3F COVER FLAT PATTERN****D3473-3 COVER**TOP COPY  
RETURN TO  
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WORK ORDER**NOTES:**

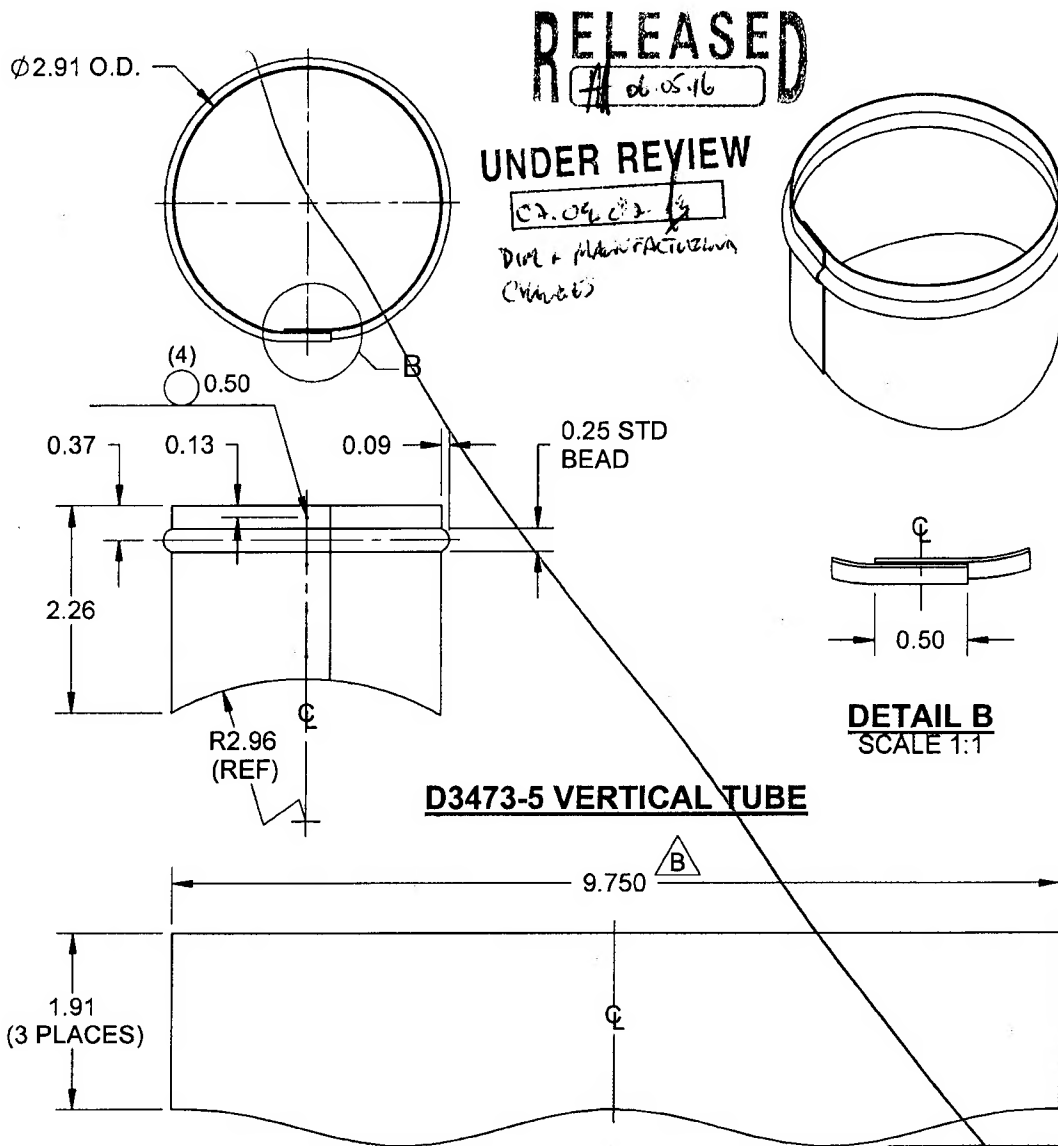
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH, 26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

**D3473-5F VERTICAL TUBE FLAT PATTERN****NOTES:**

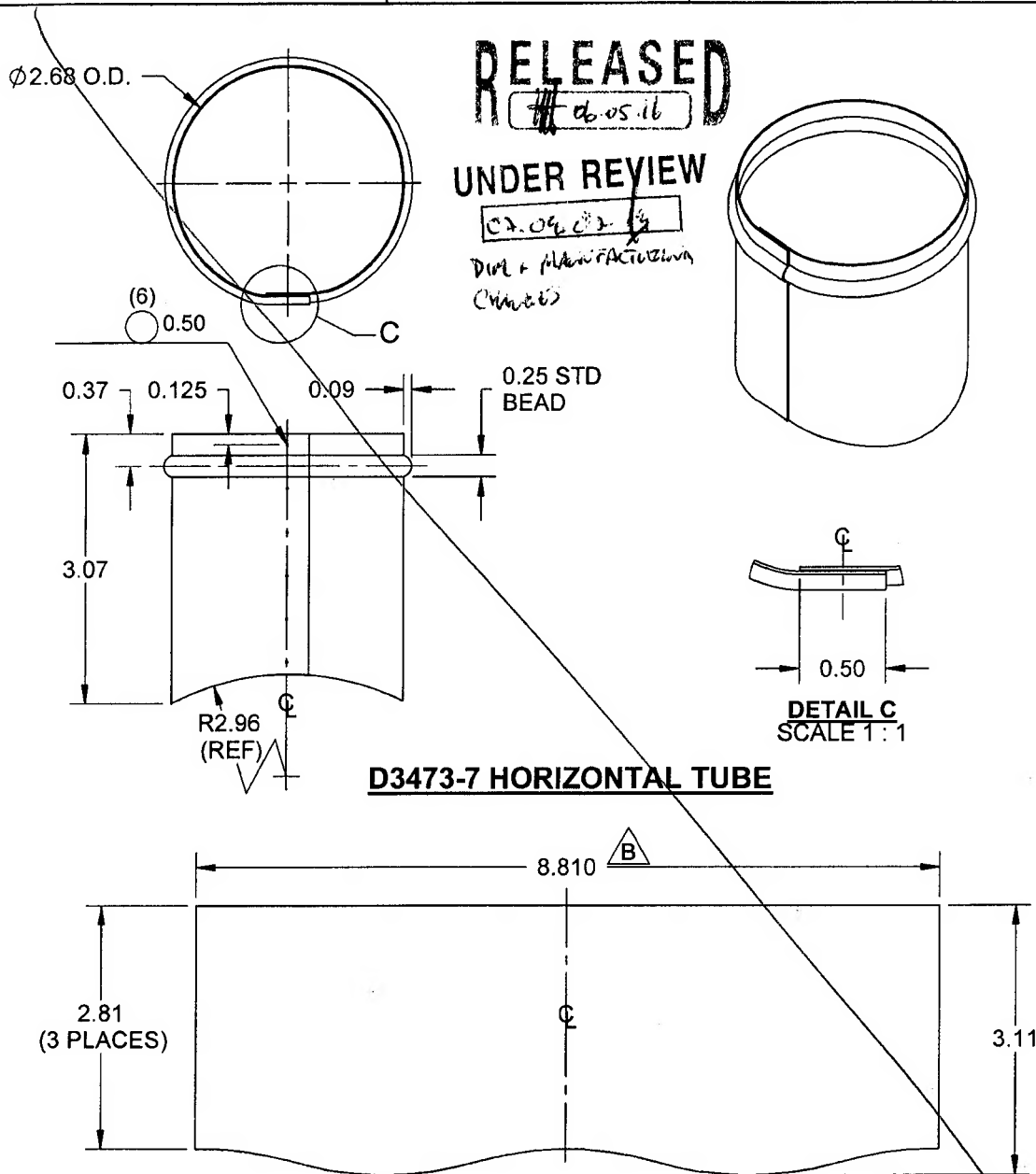
- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

**D3473-7 HORIZONTAL TUBE****D3473-7F HORIZONTAL TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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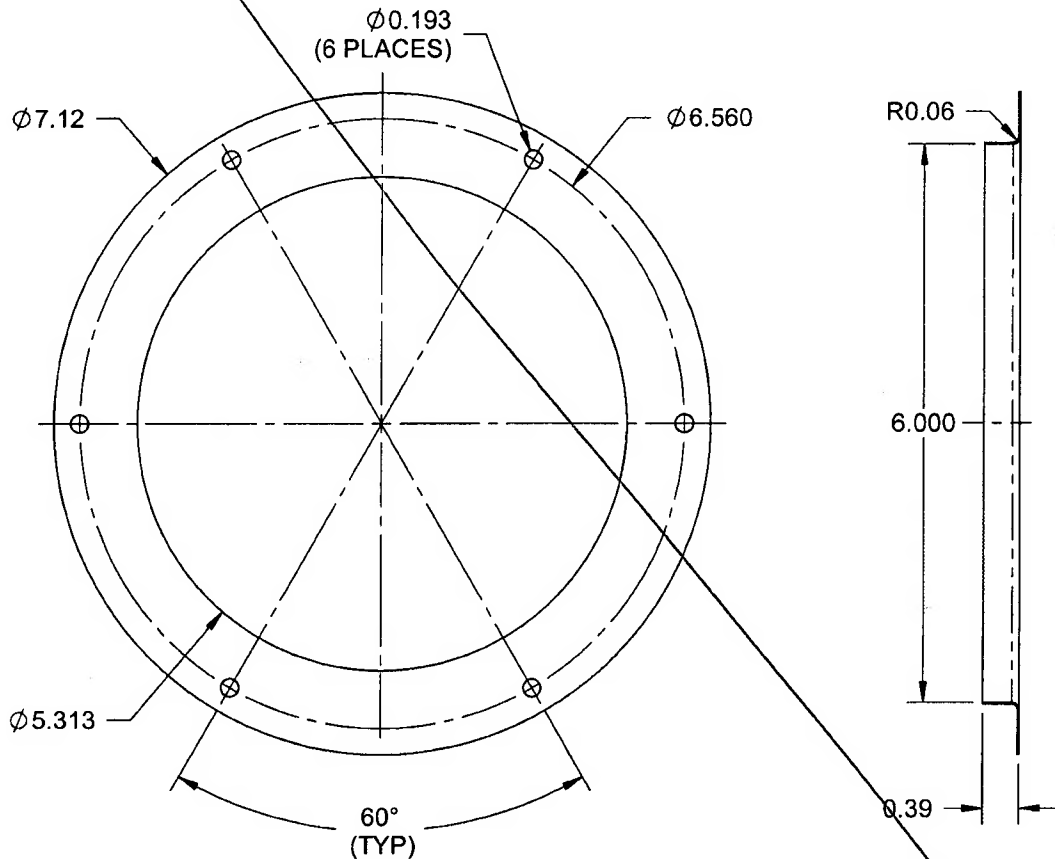
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DATE 06.05.16	TITLE BLOWER INLET ADAPTER		SCALE 1:2

**UNDER REVIEW**

02.09.16  
Diel + Manufacturing  
Changes

**RELEASED**  
06.05.16**D3473-9F FLANGE FLAT PATTERN****D3473-9 FLANGE BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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